

# Work Order ID 63667

Tuesday, November 09, 2010 12:52:39 PM

Page 1

Item ID: D4019-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib

Start Date: 11/9/2010 Start Qty: ~~6.00~~ <sup>3</sup>

Required Date: 11/16/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MP

Date: 10-11-9

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4019

100



Large Fab

Large Fab

Memo

1- Cut tube as per dwg D4019  
2- remove identification marks and deburr

0.00

0.00

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY  
10-11-10

SAD  
10-11-69

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S1011/10

120



Packaging

Packaging

Identify as per dwg & Stock Location: B/C

Memo

0.00

0.00

10-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63667**

Tuesday, November 09, 2010 12:52:40 PM

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Item ID: D4019-3

Accept

Revision ID:

Item Name: Rib

Start Date: 11/9/2010 Start Qty: 6.00

Required Date: 11/16/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10-11-10

MF  
10-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 09, 2010 12:52:39 PM

Page 1

Work Order ID: 63667



Parent Item: D4019-3



Parent Item Name: Rib

Start Date: 11/9/2010

Required Date: 11/16/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC IPP Rev:B as  
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg revC  
DD 10.04.20 verified by:EC IPP Rev:D as per dwg revD DD 10.08.18  
verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS0.750W.06 2		Purchased	No			100	f	147.2282	1.75	11.05263			



6061-T6 SQ Tube .75 x .75 x .062W



SAD 10-11-09

Location	Loc Qty	Loc Code
MAT	69.55297	
114573	22.1055	
114640	47.44747	
MAT06	77.6752	
103069	38.0526	
104422	15.5263	
16441	4.07	
9671	20.0263	

5.5263

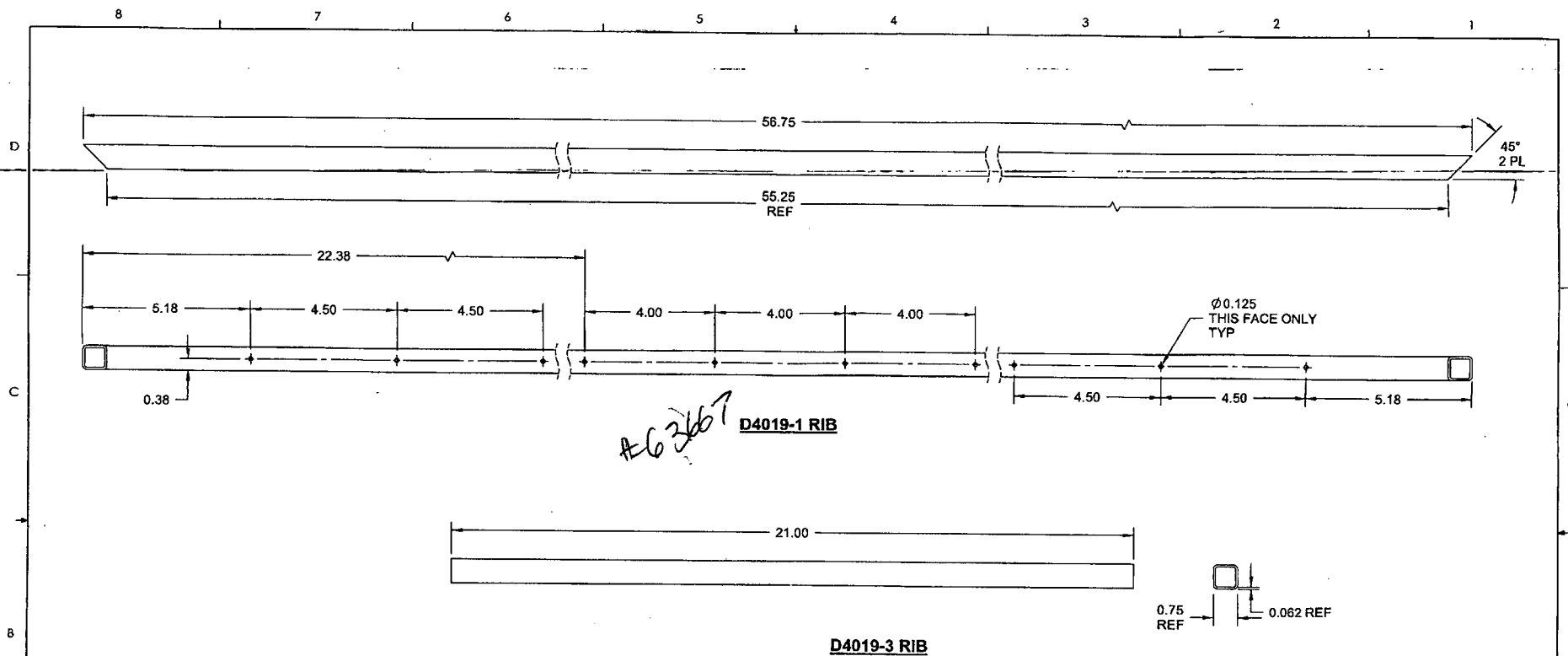
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
10.08.12 QP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/6 (OR AMS 4160)  
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs  
-3: 0.77 lbs

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.		D4019	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID SHORT BASKET	
DATE	10.08.05	NTS	
COPYRIGHT © 2010 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Receiving Report

Date: 10/5/10

Batch No: M114690

Supplier: TW Metal

Dart P/O: 11825

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☒ No ☐  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☒ No ☐ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection ☒ N/A ☐  
 Work Order 1010512 N/A ☒

**Discrepancies**

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: [Signature]  
 Date: 10/5/11  
 Received/Costing: [Signature]  
 Initial: [Signature]

Location



100 Constitution Drive  
P.O. Box 644  
Exton, PA 19341-0644

\* INVOICE \*

REMIT TO:

TW METALS, INC  
PO. BOX 933014  
ATLANTA

RECEIVED MAY 13 2010

GA 31193-3014

SALES OFFICE 585-768-5600

FED ID: 25-0883470

SOLD TO:

DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY ON K6A 1K7  
CANADA

SHIP TO:

DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY ON K6A 1K7  
ONTARIO CANADA

YOUR ORDER NO.		YOUR ORDER NO.		DATE SHIPPED	DATE INK XED	INVOICE NUMBER
P011825				05/05/10	05/05/10	80394474
SHIP	BAX 3-5 DAY	C	1203820	NET 30 DAYS		
QUANTITY		ITEM DESCRIPTION		UNIT PRICE	UNIT MEASURE	AMOUNT
1		D6061-T6 3/4 SQ X .065 WA RD CORNER		120.000	FT	
		ECCN:EAR99		10	EA	
		LENGTH: 12 FT ML				420.00

1244  
.. 1236

INVOICE NO.	QUANTITY	UNIT PRICE	UNIT MEASURE	AMOUNT	SALES TAX	TOTAL INVOICE
420.00	.00	.00	.00	.00	.00	420.00
ORIGINAL				IF PAID WITHIN DISCOUNT PERIOD DEFLECT	.00000	

THANK YOU FOR THIS ORDER

TERMS AND CONDITIONS APPLICABLE TO THE SALE OF THESE PRODUCTS ARE SET FORTH ON THE REVERSE SIDE FOR YOUR CAREFUL REVIEW.

DATE FILLED

DATE SHIPPED

PROJECT TYPE WORK SPECIFIED

41.000

12.5000

LENGTH

WIDTH

41.000

41.000

*Handwritten signature*

DATE FILLED

STB/CL: 205020

10

PC: 225809 ST: 690045130000

BOEN: 124898

12 FT ML 10 SHP 120 000 FT

12 FT ML

LENGTH

WIDTH

OPERATING PHONE

PHONE NO

COLLECT

BAX 3-5 DA

CHICAGO

CN K6A 1K7

CHICAGO CANADA

CN K6A 1K7

HARTSBURY ON

1210 KENNEDY ST

DAVE AIRSPACE LTD

SHIP TO:

DATE: 05/11/10 CONFIRMED

QST NUMBER 1203820 NET WT:

FROM: CHIC

ORDER NO: 120394474

PAGE 1

PACKING SLIP



NETALS



PACKING SLIP

ORDER NO. 80394474 FROM: CHIC PAGE 2

ORDER NUMBER: 1203820 NET WEIGHT: 24.710 RFO DATE: 05/11/10 CONFIRMED

SHIP TO:

DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAMBURG ON A43  
ONTARIO CANADA  
C K6A 1K7

SHIP FROM: CHICAGO  
605 TILGHMAN  
HAMBURG ON A43  
IL 6018

PLEASE BE FOUND UNDER THE TECHNICAL RESOURCES TAB, PRODUCT STATISTICS  
AND THE INVENTORY TABS. IF YOU DO NOT HAVE WEB SITE ACCESS  
AND WE WILL SEND A COPY OF OUR CURRENT

WARRANTY

THE MATERIAL SUPPLIED ON THIS PURCHASE ORDER AND  
THE TECHNICAL RESOURCES TAB, PRODUCT STATISTICS  
AND THE INVENTORY TABS. IF YOU DO NOT HAVE WEB SITE ACCESS  
AND WE WILL SEND A COPY OF OUR CURRENT

Date: 5/05/10

These commodities have been exported from the United States in accordance  
with the U.S. Export Control Laws, export administrations regulations.

PLEASE RE-ENTER THIS ORDER

TERMS AND CONDITIONS APPLICABLE TO THE SALE  
OF THESE PRODUCTS ARE SET FORTH ON THE  
REVERSE SIDE FOR YOUR CAREFUL REVIEW.



# KAISER ALUMINUM FABRICATED PRODUCTS

**CERTIFIED TEST REPORT**  
<http://Certs.KaiserAluminum.com>

KAISER ALUMINUM  
FABRICATED PRODUCTS, LLC  
6573 W. WILLIS ROAD  
CHANDLER, AZ 85226

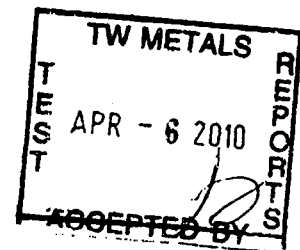
CUSTOMER PO NUMBER: <b>M49225809-1</b>		CUSTOMER PART NUMBER: <b>86913</b>		PRODUCT DESCRIPTION: <b>Seamless Tube/Pipe</b>	
KAISER ORDER NUMBER: <b>205020</b>	LINE ITEM: <b>001</b>	SHIP DATE: <b>03/27/2010</b>	KAISER LOT NUMBER: <b>F00007573</b>	ALLOY: <b>6061</b>	TEMPER: <b>T6</b>
WEIGHT SHIPPED: <b>459.000 LB</b>	QUANTITY: <b>198.000 PCS</b>	B/L NUMBER: <b>204253</b>	DIAM/DAF/THKNS: <b></b>	WIDTH: <b></b>	LENGTH: <b>12.000 FT</b>
SHIP TO: <b>TW METALS INC 235 WEST TUBEWAY DRIVE CAROL STREAM, IL 60188 USA</b>			SOLD TO: <b>TW METALS INC 760 CONSTITUTION DRIVE SUITE 204 EXTON, PA 19341 USA</b>		

## Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CON%IACS	BEND
F00007573	0001	1	48.7	46.5	15.9	N/A	N/A	N/A

## Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
D67811	.53	.29	.24	.06	.96	.06	.06	.02	.00	.00	.00	.01	.02
D67767	.62	.33	.24	.05	.96	.09	.07	.03	.00	.00	.00	.01	.02



## CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Chris Garcia, Quality System Engineer

Plant Serial: 00006613

Kaiser Order Number: 205020

Line Item: 001

*Christopher J. Garcia*



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO11825

Purchase Order Date 5/04/10

PO Print Date 5/04/10

Page Number . of 1

Order From :

VU-TWM001

TW METALS  
PO BOX 933014  
ALTANTA, GA 31193-3014  
US

Contact Name

Vendor Phone 585 768 5600

Vendor Fax 585 768 5601

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

USD

FOB

Ship To :

DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
67053

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6TS0.750W.062	6061-T6 SQ Tube .75 x .75 x .062W	5/11/10 Yes	✓ 120.00 f		\$3.5000	\$420.00

Special Inst: MATERIAL: 6061-T6 OR 6061-T62  
TUBING PER  
WW-T-700/6 OR AMS4080 OR AMS 4082  
OR  
QQ-A-200/8 OR QQ-A-225/8  
MATIAL: 6061-T6 SQUARE TUBING  
.750" X .750" X .065" WALL

PO Total:

\$420.00

**MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY**

PO Instructions:

PLEASE SHIP: BAX GLOBAL ACCT:152700192

Change Nbr:

1

Change Date: 5/04/10

No substitution or deviation without  
consent.  
Certificate of Conformity; or Material  
Certification required when applicable